

5/45

split

DART AEROSPACE LTD	Work Order:	24622-8
Description: Gas Spring	Part Number:	D2807
Dwg: D2807 Rev. C	Qty:	20 13 53
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.10.21	20
2	PG	Issue P/O: <u>2008847</u> Order as per Dwg D2807 Possible supplier: ArvinMeritor Motion Control Systems Material release note is required	AL	05/10/21	20
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	CL	05/11/21	20
4	QC6	Inspect dimensions as per Dwg D2807	2	05.12.13	20
5	GA	Install lugs and crimp as per Dwg D2807 = <u>Remove left hand lug</u> <u>Pick: using DT 8P11 Crimp 4/6. with wash & wire.</u> Qty Part Number Description Batch 2 D2807-3 Lug B23479 (4) 26625-05	FF	06.01.12	15
6	QC5	Inspect work to Step 5	FF	06.04.21	3
7	ST	Identify and Stock	CL	06/04/21	3
8	AC	Cost / part: _____	W	06.04.21	3
9	DC	Close W/O Inspect Level 21	G	06/04/21	3

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Added step 6	EC	
C	05.04.28	Reformat; Added Step 6 & 7	KJ/JLM	
D	05.06.21	Removed painting; Changed supplier	KJ/JLM	

RELEASED
11/05/2021

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06.01.16	3	Remove Camloc Supply information and camloc pin, Leave warning, use acetone.				 06.01.16 per QSI 042	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06.04.21	5	Q 028073 lugs were no good (drilled too deep) and installed on 2 gas springs. 2 shocks scrap.		Scrap: identify 2 shocks to eng. for	SJB 06/25/19	 06.05.09		 06.05.09

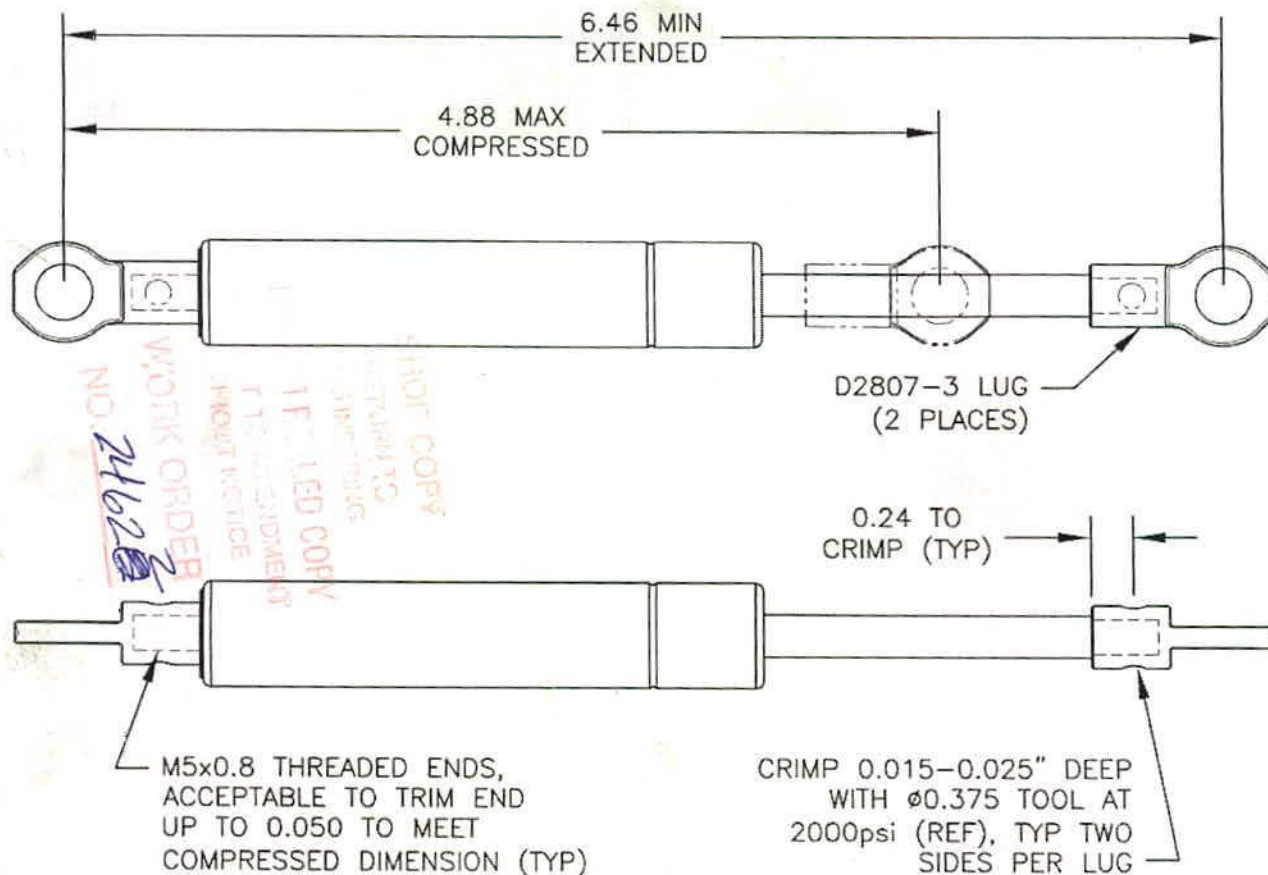
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:
Date: 06/05/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART**RELEASED**
#05-06-16

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2807
DATE		TITLE
05.05.25		GAS SPRING
		SCALE
		1:1
A	00.11.03	NEW ISSUE
B	05.03.16	ADD FINISH
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG

**D2807 GAS SPRING**

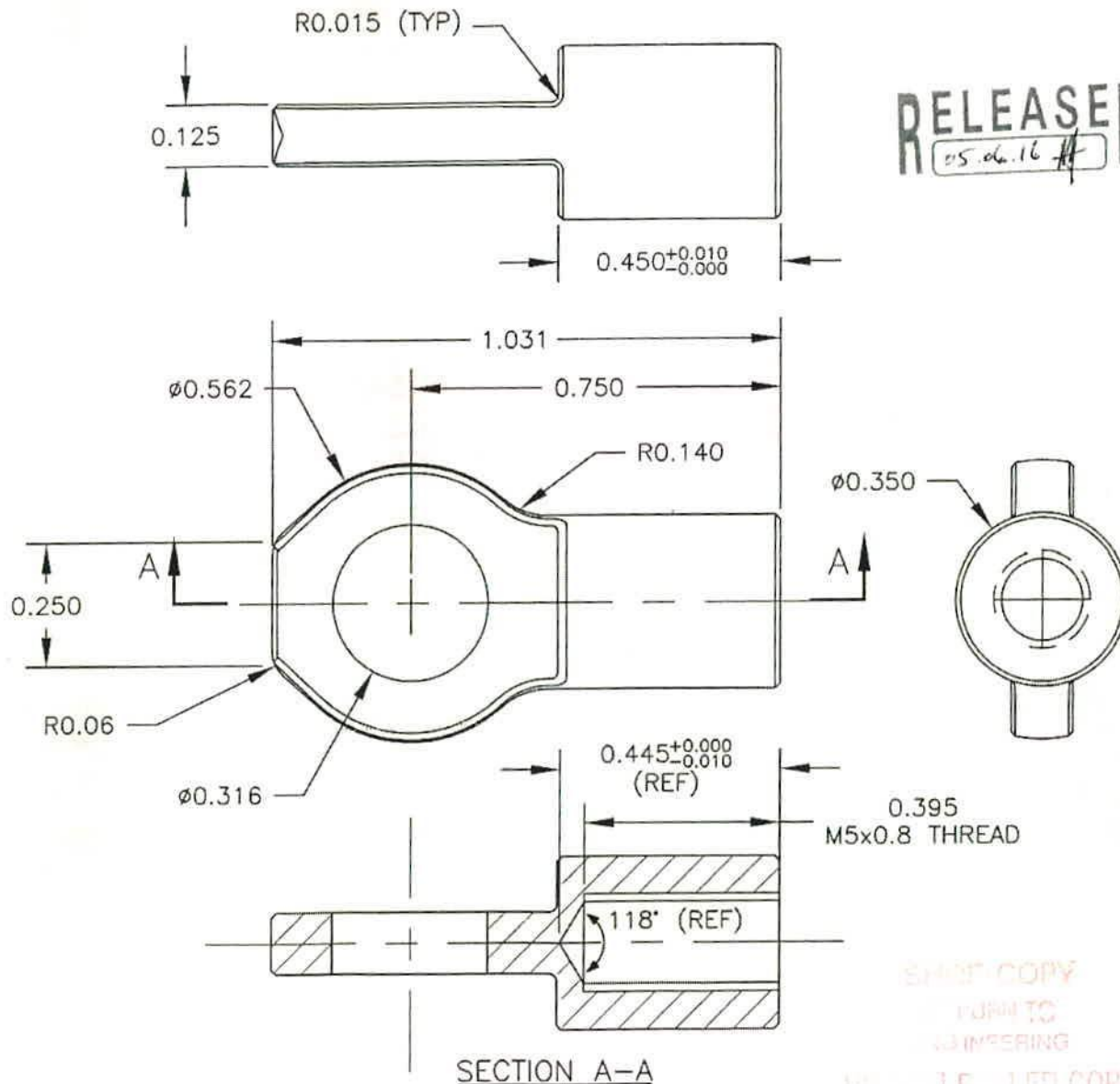
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**RELEASED**
05.06.16 *[Signature]***D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHARP COPY
TURN TO
ENGINEERING
WORK ORDER
NO. 24622

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 21, 2005
08:50 am

Work Order No : 0024622
Project Name : D2807
Project For : WK545
Work Order Type : Main
Main WO Number :
House Part Number : D2807
Description : Gas Spring
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-20-05
Est Finish Date : 11-11-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Cam 001